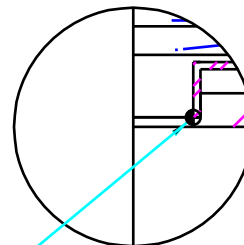


-A-

2 ND WELD

TIG

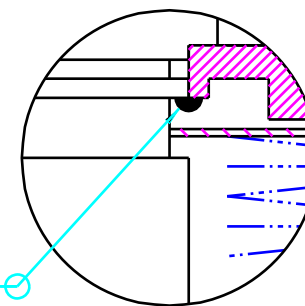


DETAIL "B"

SCALE 10X

1 ST WELD

TIG



DETAIL "A"

SCALE 10X

NOTES:

1. WELD ASSEMBLY ACCORDING TO SEQUENCE SHOWN
2. THIS IS A ULTRA - HIGH - VACUUM ASSEMBLY (UHV) KEEP THE UHV PARTS CLEAN DURING ASSEMBLY, AND WRAP UP FOR PACKING WITH ALUMINUM FOIL
3. THE ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

ALCATEL ASM-110TCL
VARIAN NCR 925 OR 936
VEECO MS-9, MS-90 OR MS-18
Du PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

3. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

0.005 [0.127] A
WHEN BELLOWS IS COMPRESSED

SEE DETAIL "A"

3 B

TIG

3 RD WELD

7.250 [184.16]

2 C

4

SEE DETAIL "B"

SECTION A - A

4.725 [120.02]
TRAVEL

REF. SOURCE

STANDARD BELLOWS CO.
375 TURNPIKE AVE.
WINDSOR LOCKS, CON. 06096
TEL: 1-860-623-2307
FAX: 1-860-623-0398

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			



ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
4	#220-104-10-AB	BELLOWS	SST	1
3	P8-620203-00	P8-60 UPPER BELLOW FLANGE	SST	1
2	P8-620202-00	P8-60 ACTUATOR SHAFT	SST	1
1	P8-620201-00	P8-60 LOWER BELLOWS FLANGE	SST	1
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGLES				
IN	0.1 (2.5)	0.030		
IN	0.01 (0.25)			
IN	0.005 (0.13)			
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES 3X MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS 2627				
DIMENSIONS & TOLERANCES IN ACCORDANCE WITH LATEST AMS 2627				
NO NET SCALE DRAWING				
DRAWN BY MUSCIA		DATE 12/22/98	CHIEF DESIGN ENGINEER D. Shu	DATE 1/27/99
CHECKED BY J. CHANG		DATE 1/23/99	OP. LEADER T.M. Kuzay	DATE 2/5/99
DESIGNER CHANG/MUSCIA		DATE 12/22/97	PROJECT MGR.	DATE
RESPONSIBLE ENGINEER J. CHANG		DATE 1/23/99	APPROVED/RELEASED	DATE
MATERIAL SEE PARTS LIST		SCALE HALF	SHEET 11	C
		DRAWING NUMBER	P8-620200-00	

THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY
ADVANCED PHOTON SOURCE
P8-60 I.D.
MONO. INTEGRAL SHUTTER
BELLOWS SHAFT &
VACUUM FLANGE ASSEMBLY